Work Order ID 63054

Tuesday, October 19, 2010 10:18:10 AM

Item ID: D3442-3 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Shim

Start Date: 10/19/2010 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 10/26/2010 **Req'd Qty:** 4.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 10-10-21 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D3442 / Revision Nbr: Rev A									
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3442 ☐Dwg Rev: A ☐Prog Rev: A ☐2-Deburr if necessary					B10-10-21			9
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				B10-10-21			
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo** SH-03	0.00				9			10.10.21
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 63054

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Item Name: Shim

Start Date: 10/19/2010 **Start Qty:** 4.00 **Cust Item ID:**

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: WA	0.00				9			
Packaging									
Packaging	**Memo**	0.00							
	*****STOCK IN BASKET CELL*****								
140	QC21- Final Inspection - Work Order Release	0.00							
QC									
Quality Control	**Memo**	0.00							

SAD 10-11-02

CK 10/11/03 MF 10-11-2

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, October 19, 2010 10:18:14 AM

Work Order ID: 63054

Parent Item: D3442-3

Parent Item Name: Shim

Start Date: 10/19/2010 **Required Date:** 10/26/2010

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP A□05.09.02□New issue□KJ/JLM□
IPP B 07.07.23 waterjet EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased	No			100	sf	90.2896	0.025	0.105263			
304/316 .032 Sheet										10-10-21			

Location	Loc Qty	Loc Code
MAT20	90.2896	
109023	30.2896	
109057	60	

9

109057

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD	Work Order:	63054
Description: Shim	Part Number:	D3442-3
Inspection Dwg: D3442 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.747	✱		V BOZ	
0.750	+/-0.010	.748	✱		V	
0.750	+/-0.010	.747	✱		V	
1.625	+/-0.010	1.626	✱			

Measured by:	RB	Audited by:		Prototype Approval:	N/A
Date:	10-10-21	Date:	10.10.21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	DD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

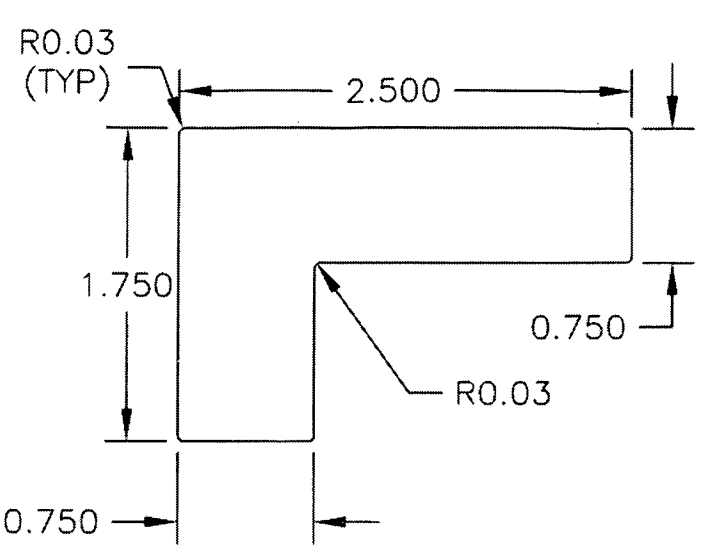
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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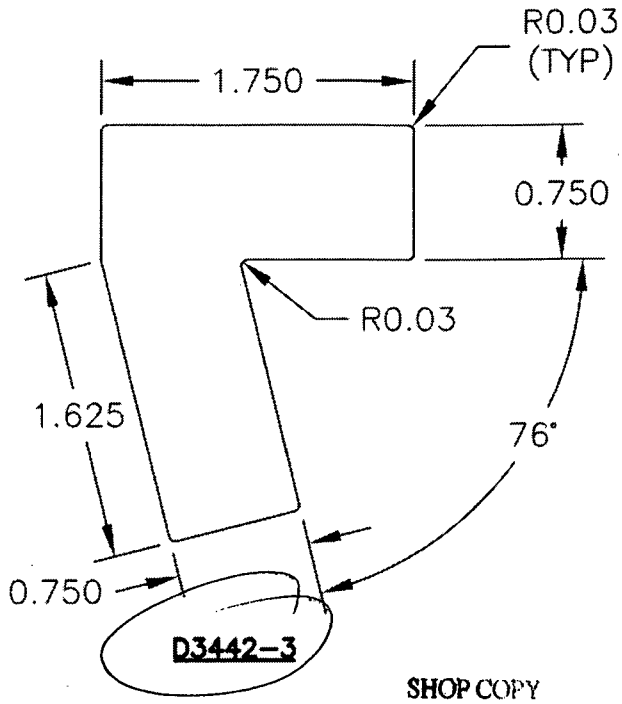
NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
PH	PH		
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3442	SHEET 1 OF 1
DATE		TITLE	SCALE
05.06.03		SHIM	1:1

A	05.06.03	NEW ISSUE



D3442-1

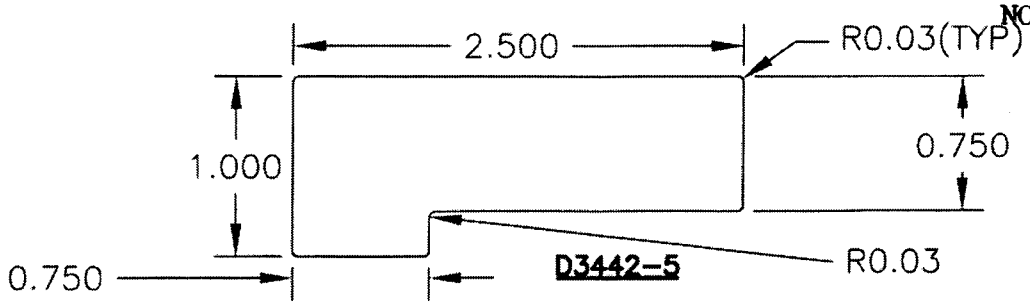


D3442-3

D3442-1/-3 SHIM

1) MATERIAL: AISI 304/316 SS SHEET 21 GAUGE (0.034 THICK) (REF DART SPEC M304S21GA)
2) FINISH: NONE
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63054
BS 10-10-05



D3442-5

D3442-5 SHIM

1) MATERIAL: AISI 304/316 SS SHEET 16 GAUGE (0.063 THICK) (REF DART SPEC M304S16GA)
2) FINISH: NONE
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.08.19

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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